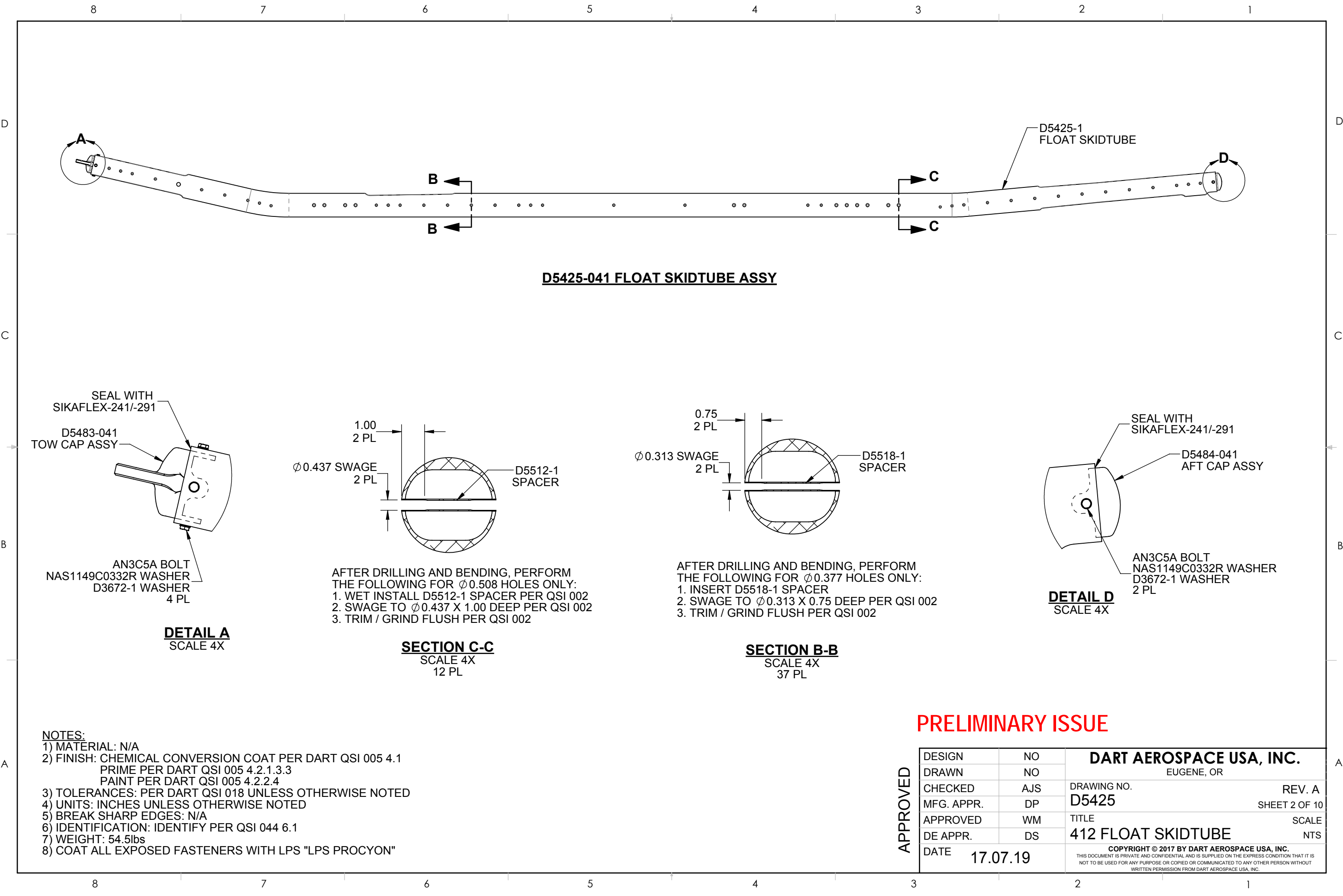


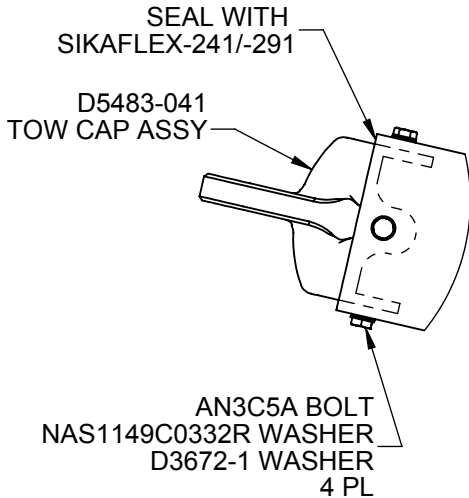
PRELIMINARY ISSUE

APPROVED

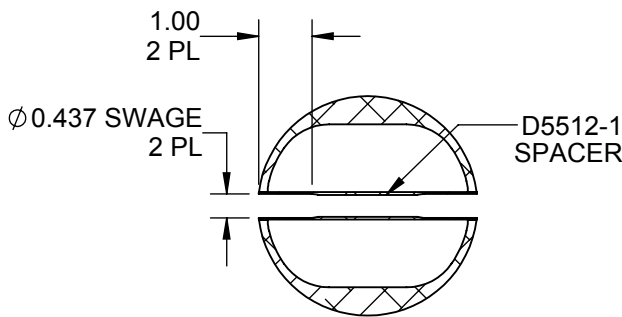
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REV.	DESCRIPTION		BY	DATE
DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR		
DRAWN	NO			
CHECKED	AJS	DRAWING NO.		REV. A
MFG. APPR.	DP	D5425		SHEET 1 OF 10
APPROVED	WM	TITLE		SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE		NTS
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D5425-041 FLOAT SKIDTUBE ASSY

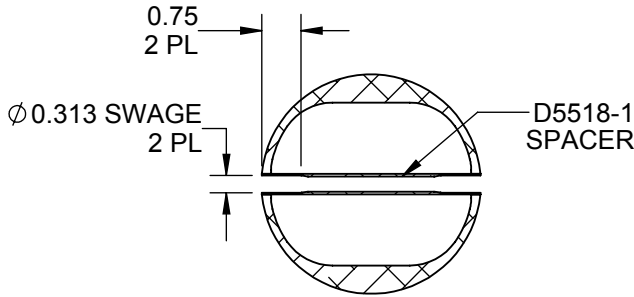


DETAIL A
SCALE 4X



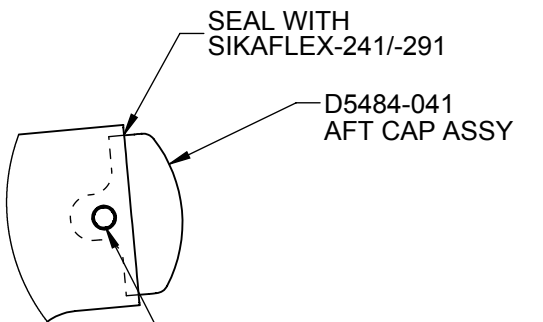
AFTER DRILLING AND BENDING, PERFORM
THE FOLLOWING FOR Ø 0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø 0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION C-C
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM
THE FOLLOWING FOR Ø 0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø 0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B
SCALE 4X
37 PL



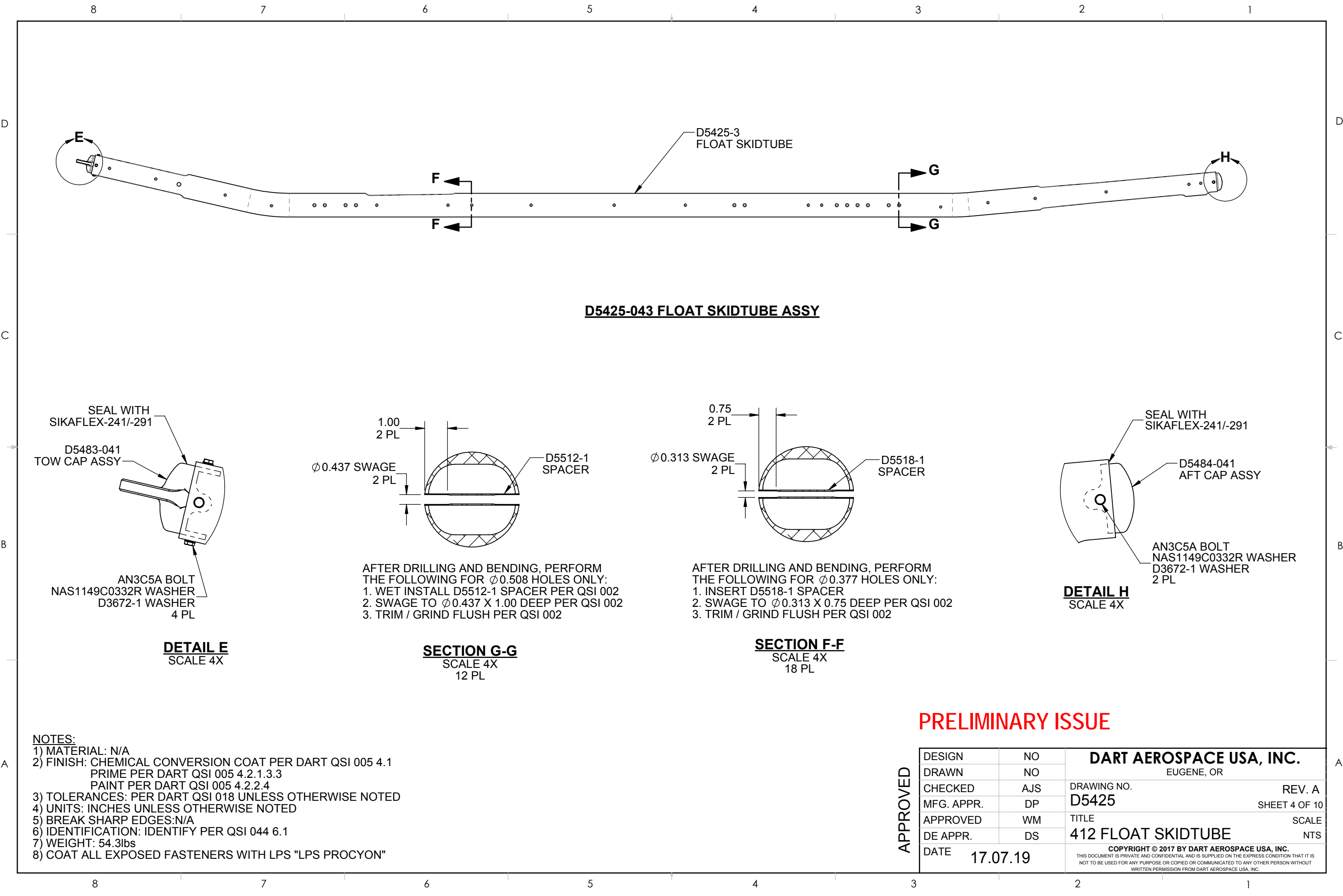
DETAIL D
SCALE 4X

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 54.5lbs
 - 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

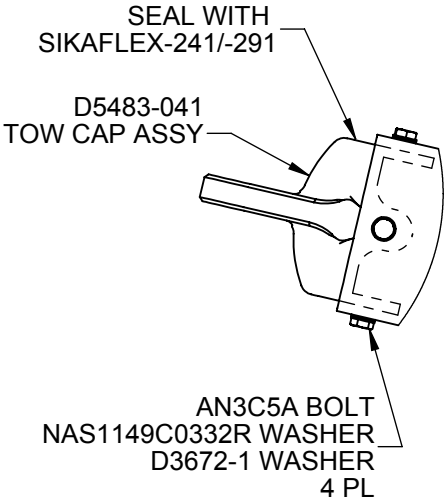
PRELIMINARY ISSUE

APPROVED

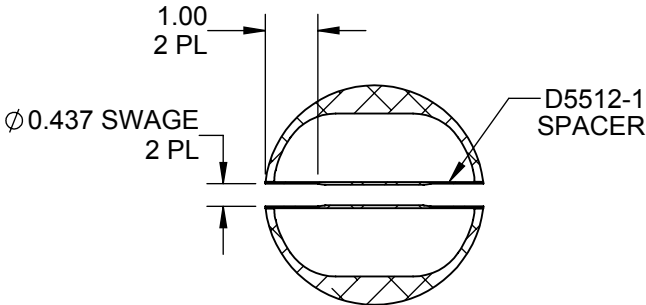
DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	NO		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DP	D5425	SHEET 2 OF 10
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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D5425-043 FLOAT SKIDTUBE ASSY

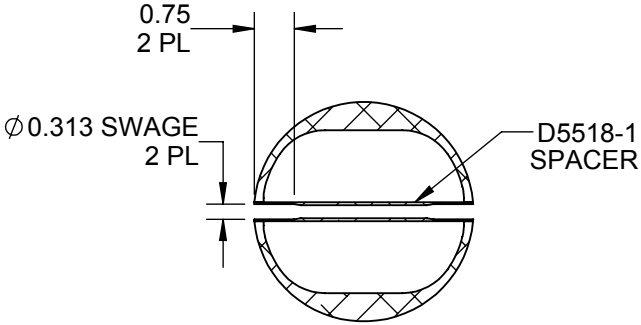


DETAIL E
SCALE 4X



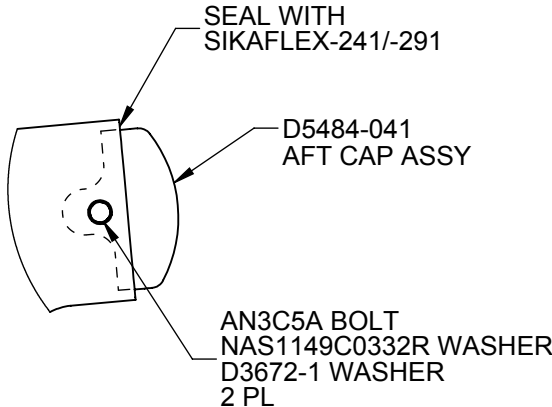
AFTER DRILLING AND BENDING, PERFORM
THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION G-G
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM
THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION F-F
SCALE 4X
18 PL

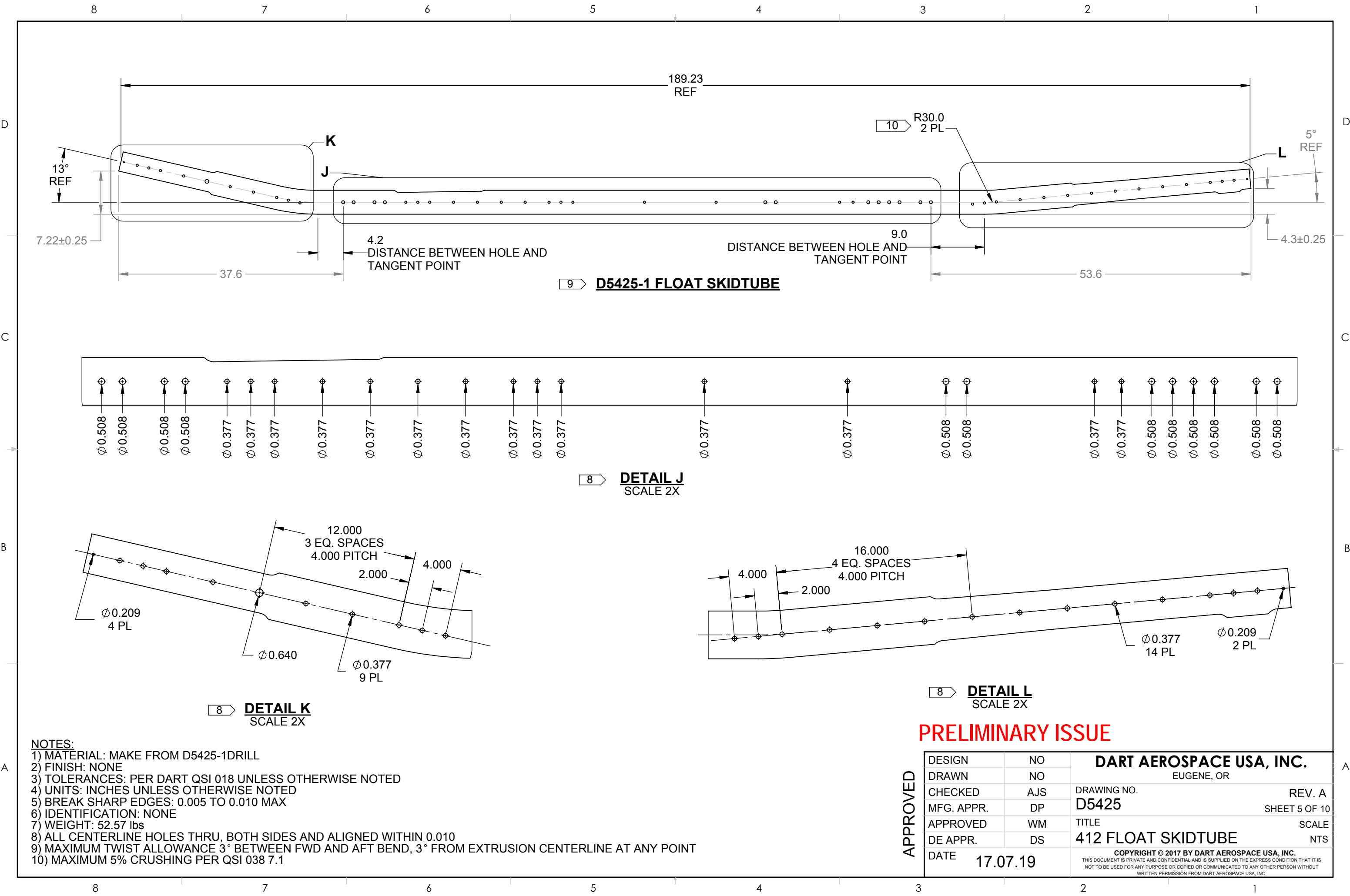


DETAIL H
SCALE 4X

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 54.3lbs
 - 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

PRELIMINARY ISSUE

APPROVED	DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	NO		
	CHECKED	AJS	DRAWING NO.	REV. A
	MFG. APPR.	DP	D5425	SHEET 4 OF 10
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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9 **D5425-1 FLOAT SKIDTUBE**

8 **DETAIL J**
SCALE 2X

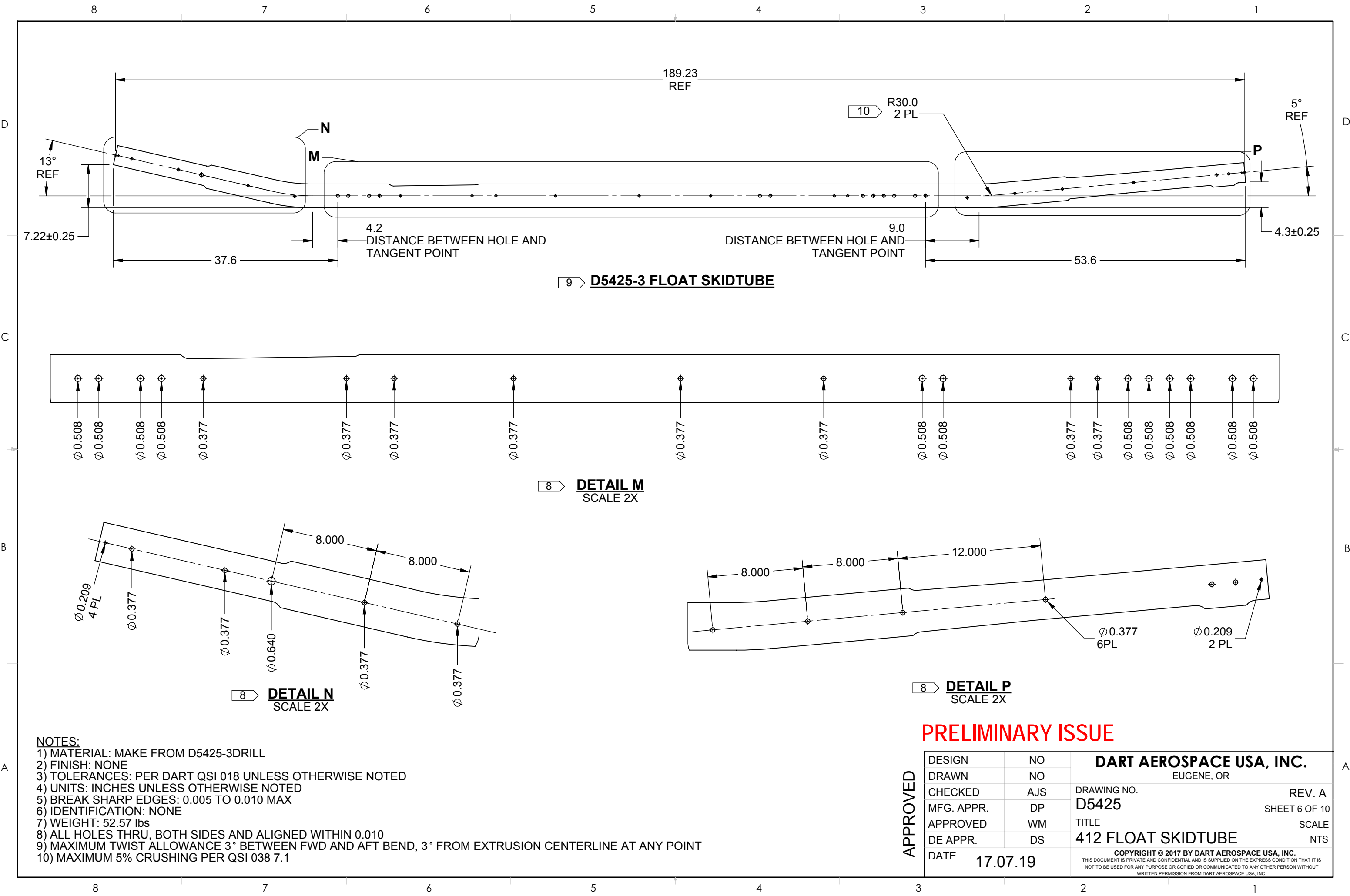
8 **DETAIL K**
SCALE 2X

8 **DETAIL L**
SCALE 2X

- NOTES:
- 1) MATERIAL: MAKE FROM D5425-1DRILL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 52.57 lbs
 - 8) ALL CENTERLINE HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
 - 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM EXTRUSION CENTERLINE AT ANY POINT
 - 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

PRELIMINARY ISSUE

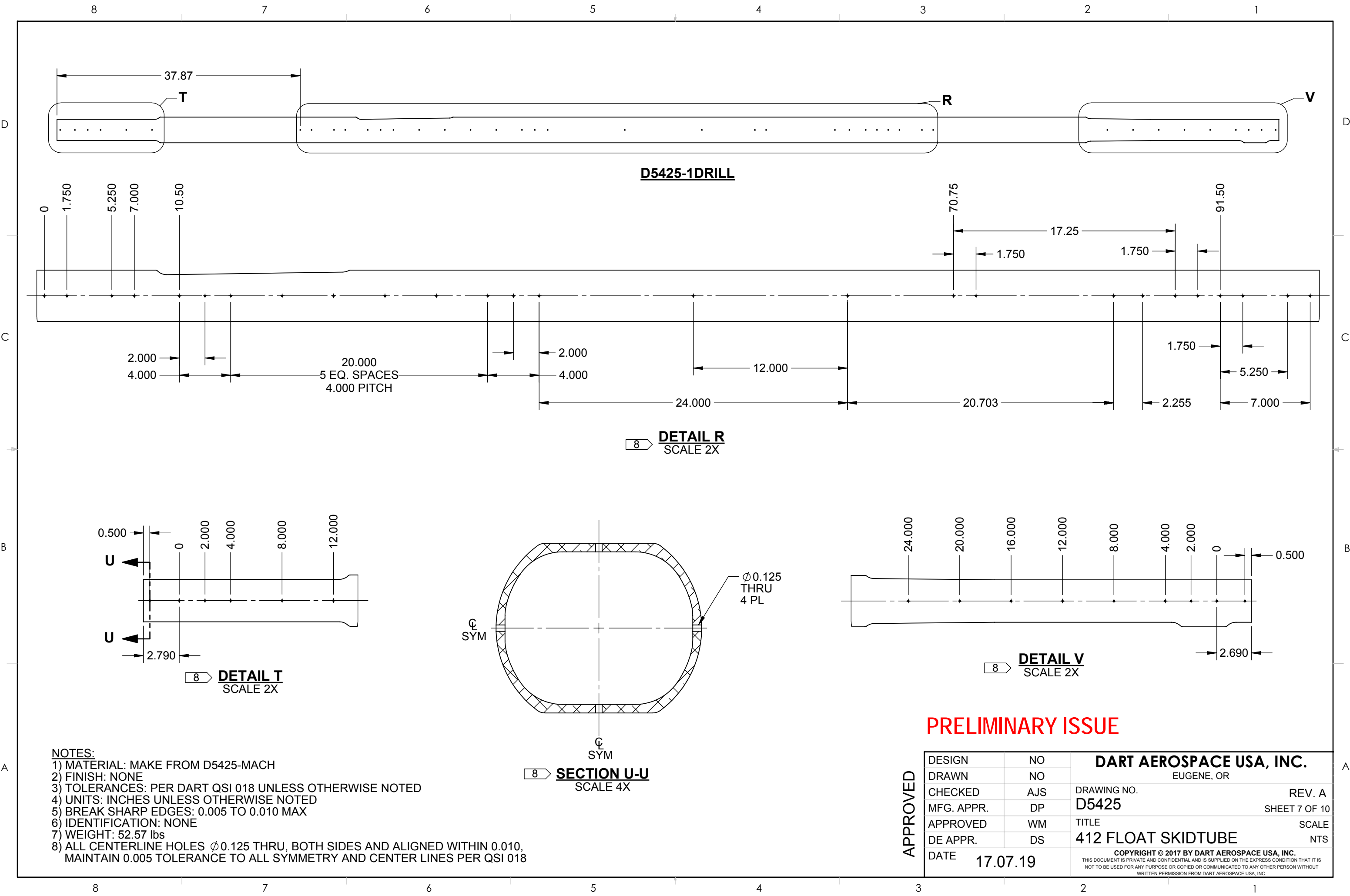
APPROVED	DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	NO		
	CHECKED	AJS	DRAWING NO.	REV. A
	MFG. APPR.	DP	D5425	SHEET 5 OF 10
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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- NOTES:
- 1) MATERIAL: MAKE FROM D5425-3DRILL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 52.57 lbs
 - 8) ALL HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
 - 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM EXTRUSION CENTERLINE AT ANY POINT
 - 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

PRELIMINARY ISSUE

APPROVED	DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	NO		
	CHECKED	AJS	DRAWING NO.	REV. A
	MFG. APPR.	DP	D5425	SHEET 6 OF 10
	APPROVED	WM	TITLE	SCALE
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NOTES:

- 1) MATERIAL: MAKE FROM D5425-MACH
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 52.57 lbs
- 8) ALL CENTERLINE HOLES Ø0.125 THRU, BOTH SIDES AND ALIGNED WITHIN 0.010, MAINTAIN 0.005 TOLERANCE TO ALL SYMMETRY AND CENTER LINES PER QSI 018

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APPROVED	DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	NO		
	CHECKED	AJS	DRAWING NO.	REV. A
	MFG. APPR.	DP	D5425	SHEET 7 OF 10
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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